

Work Order ID 77068

77068

Page 1

November-25-11 8:35:55 AM

Item ID: D206-642-151

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube

Start Date: 25/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 09/12/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M.C.J Date: 11/11/25

Tooling:

Date:

Run Start *NR1*

QC: _____ Date: _____

SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3804	A
IIN-D206-642	O

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-151

CHG001

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00				①			
110	Memo	0.00							
Skidtubes	1-Deburr Fwd edge of tube								
Skidtubes	2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804								
	3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.								
	Pick:								
	Qty Part Number DescriptionBatch								
	A/R Aluminum Rod <u>M117889</u>								
	4-Grind weld flush to cap on top surface only								
	5-Cut Aft end as per dwg D3804 from front of tube and Deburr								
	6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804								
	7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.								
	8-Drill pilot holes using Dt8166 & DT8169D & DT9771.								
	9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.								
	10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.								

SAQ 11-11-29

BCU 11-29

SOO 11-12-05

11/12/05

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Run Start ***NR1***

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11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

16- Open Aft cap hole #6.
****no wearplate holes for this skidtube****

17-Deburr tube and blow out chips from inside the tube

120

QC6- Inspect dimensions to drawing 0.00

120

QC

Memo 0.00

Quality Control

DL
11/12/05

S 11/12/05

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		DL 11/12/05					
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		SAD 11-12-05 (1)					
160 *160* Skidtubes Skidtubes Skidtubes	Skidtubes Memo 1-Open holes to finished size as per Dwg D3804, (without cutting fluid) 2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid) 3-Deburr and blow out all chips from inside the tube	0.00 0.00		DL 11/12/05					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 25/11/2011 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 09/12/2011 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170 QC6- Inspect dimensions to drawing 0.00

170

QC Memo 0.00

Quality Control

180 Skidtubes 0.00

180

Skidtubes Memo 0.00

Skidtubes 1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required *AC 11/12/05*

2-Bond D2654-1 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: *11-12-5* Time: *5:50*
Finish Date: *11-12-06* Time: *7:00*

Pick:

Qty Part Number Description Batch

A/RSikaflex-291 *M119399*

Sikaflex expire date: *12-8-13*

DP 11-12-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date: 25/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 09/12/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

1 2 BE11-12-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

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Start Date: 25/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 09/12/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

0.00

200

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-remove alodine from around hole and prepare for welding

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

QtyPart NumberDescriptionBatch
A/RAluminum Rod M117889

3-Grind welds flush as per Dwg D3804.

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod NONE BE 11-12-06

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr

DP 11-12-6

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

77068

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N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

210

210

HandFinish

Hand Finishing

HandFinishing

Memo

Install D2680-041 Nut Plate as per Dwg D3804

0.00

0.00

0.00

0.00

0.00

0.00

215

215

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

QC10- Inspect visual per QSI004- ground welds

Memo

220

220

QC

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 77068***77068***

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 25/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 09/12/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	QC5- Inspect part completeness to step on W/O	0.00							
230									
QC	Memo	0.00							
Quality Control									
240	Pressure Wash per QSI005 4.3	0.00							
240									
HandFinish	Memo	0.00							
Hand Finishing									
250	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
250									
Powdercoat	Memo								
Powder Coating									

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:30 0.00
320 OF
9:00

M119480

HX M-L 11/12/10

HX M-L 11/12/12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

260

QC3- Inspect Part Finish

0.00

260

QC

Memo

0.00

Quality Control

12/11/12 12/12/12

270

HandFinishing

0.00

270

HandFinish

Memo

0.00

Hand Finishing

1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive.

12/11/12 12/12/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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77068

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N900040100

Setup Start *NS1*

Stop *NS2*

*** 1 ***

Cust Item ID:

*** 1 ***

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

**Insp.
Stamp**

0.00

280

HandFinishing

0.00

HandFinish

Memo

Hand Finishing

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 1119443

Sikaflex expire date: 12/6/

2- Install wearplate as per dwg

2-Wing Walk as per Dwg D3804 and QSI 005 4.4

Batch: 41119090

290

QC3- Inspect Part Finish

0.00

290

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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300 QC5- Inspect part completeness to step on W/O

0.00

300

QC

Memo

0.00

Quality Control

310

0.00

310

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-151

Location: _____

PPP Rev: _____

320

0.00

320

QC

Memo

0.00

Quality Control

QC21- Final Inspection - Work Order Release

11/12/14

W/O:		WORK ORDER CHANGES					
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Picklist Print

November-25-11 8:36:00 AM

Page 1

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Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV.N DD VERF:EC
REV:B 11.09.16 PER IIN REV.O DD VERF:EC

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2620		Manufactured	No			110	Each	19.0000	1	1			
										**	SAD	11-11-29	

D2620

Skidtube, 206 Skidtube

Location Loc Qty Loc Code

LG	19	
71616	3	
71617	6	
74459	2	
74460	3	
74461	5	

D2647		Manufactured	No			110	Each	237.0000	1	1			
										**	BE11-11-29		

D2647

Cap

Location Loc Qty Loc Code

LG002	237	
55352	3	
73826	124	
75482	110	

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D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-04

Purchased

No

180

Each

15,285.00

52

52

CR3212-4-04

Cherry Rivet

**

DL 11/12/05

Location

Loc Qty

Loc Code

ST331

5295

116471

78

117816

3

118686

1

118840

16

119017

5187

119073

10

st510

9990

119075

9990

53

D2654-1

Manufactured

No

180

Each

14.0000

1

1

D2654-1

Web

**

DP 11-12-5

Location

Loc Qty

Loc Code

LG

14

73794

1

73799

1

75474

6

75475

1

75476

4

75477

1

1

D3286-1

Manufactured

No

180

Each

165.0000

2

2

D3286-1

Doubler

**

DL 11/12/05

Location

Loc Qty

Loc Code

LG002

165

74111

1

74441

4

74872

49

75484

111

2

November-25-11 8:36:00 AM

Shop Packet Print

Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-25-11 8:36:00 AM

Page 3

Work Order ID: 77068

77068

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

200

Each

176.0000

19

19

D2649

Cross Bolt Spacer

**

BE 11-12-06

B 73859

Location

Loc Qty

Loc Code

LG

22

68224

2

71355

2

72704

2

72841

11

73855

5

LG001

154

65317

1

68507

11

73390

8

73857

21

73858

109

73860

4

D3286-3

Manufactured No

200

Each

121.0000

2

2

D3286-3

Spacer

**

BE 11/12/06

B 75483

Location

Loc Qty

Loc Code

LG

40

74870

40

LG001

1

74117

1

LG002

80

75483

80

2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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November-25-11 8:36:00 AM

Page 4

Work Order ID: 77068

77068

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 1.00

Required Qty: 1.00

D2680-041

Manufactured No

210 Each

30.0000

1

1

D2680-041

Nut Plate

**

DP 11-12-6

Location

Loc Qty

Loc Code

LG

1

73334

1

ST020

29

73854

29

CR3212-4-03

Purchased No

210 Each

1,870.000

1

2

CR3212-4-03

Cherry Rivet

**

DP 11-12-6

Location

Loc Qty

Loc Code

FB

2

110139

2

ST331

1868

114859

868

119017

1000

AN960JD416

NAS1149D0463J

Purchased No

210 Each

0.0000

1

1

AN960JD416

Washer

CCR264SS3-3

Purchased No

210 Each

1,113.000

2

2

CCR264SS3-3

Cherry Rivet

**

1118384 (x1) 11-12-13

DP 11-12-6

Location

Loc Qty

Loc Code

FP

2

113973

2

ST311

159

117849

159

ST317

952

119017

952

November-25-11 8:36:00 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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November-25-11 8:36:00 AM

Page 5

Work Order ID: 77068

77068

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

210

Each

378.0000

1

1

MS27039-4-06

Screw

**

21 11/12/13

Location

Loc Qty

Loc Code

ST291

378

119075

378

D2651-1

Manufactured

No

270

Each

709.0000

6

6

D2651-1

Plug

**

21 11/12/13

Location

Loc Qty

Loc Code

FP

709

57869

1

66445

10

69018

2

70839

2

71037

31

73827

663

D2651-3

Manufactured

No

270

Each

1,205.000

6

6

D2651-3

O-Ring

**

21 11/12/13

Location

Loc Qty

Loc Code

FP

1205

61962

12

73489

193

73828

1000

21 11/12/13

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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November-25-11 8:36:00 AM

Page 6

Work Order ID: 77068

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

77068

D206-642-151

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3873-1

Manufactured No

280 Each

730.0000 14 14

D3873-1

Bushing

**

11/12/13

Location

Loc Qty

Loc Code

ST088

730

64760

1

68247

4

73829

19

73830

16

73832

400

75481

290

x14

D2646

Manufactured No

280 Each

229.0000 1 1

D2646

Aft Cap

**

11/12/13

Location

Loc Qty

Loc Code

FP002

212

73294

14

73825

198

x1

FP004

8

68280

5

70945

1

71070

2

FP005

4

71038

4

FP006

5

62678

5

D3805-041

Manufactured No

280 Each

0.0000 1 1

D3805-041

Wearplate Assembly Fwd, Low Gear

**

1375486 (x1) 11/12/13

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 7

Work Order ID: 77068

77068

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-08

Purchased

No

280

Each

1,633.000

2

2

MS27039-1-08

Screw

**

Handwritten initials

11/12/12

Location

Loc Qty

Loc Code

ST291

1633

117423

115

118378

118

118910

400

119075

500

119109

500

x2

MS21042L3

Purchased

No

280

Each

7,961.000

7

7

MS21042L3

Nut

**

Handwritten initials

11/12/13

Location

Loc Qty

Loc Code

ST300

213

117441

16

117885

35

118451

5

118927

157

ST516

5994

119017

5994

ST518

1754

119075

1754

x7

D3805-045

Manufactured

No

280

Each

5.0000

1

1

D3805-045

Wearplate Assembly Aft, Low Gear

**

1375496

(x1) 11/12/13

Location

Loc Qty

Loc Code

FP

5

73817

1

74896

1

74938

3

Dart Aerospace Ltd

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November-25-11 8:36:00 AM

Page 8

Work Order ID: 77068

77068

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD10L NAS1149D0332J Purchased

No

280

Each

0.0000

2

2

AN960JD10L

Washer

AN3-37A

Purchased

No

280

Each

1,924.000

7

7

AN3-37A

Bolt

**

M 118389(x2) MU 11/12/13

**

MU 11/12/13

Location

Loc Qty

Loc Code

ST354

4

117619

4

ST518

1920

119086

1920

x7

NAS1149D0363J

Purchased

No

280

Each

3,569.000

7

7

NAS1149D0363J

Washer

**

MU 11/12/13

Location

Loc Qty

Loc Code

ST019

16

117505

16

ST295

2921

119537

2921

ST298

632

117601

68

118077

1

118612

55

118968

508

x7

W/O:		WORK ORDER CHANGES					
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ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 77068 M.C.J

11/11/25

RELEASED
UP 09.03.03
per ECN 09-536

A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	97		
DRAWN	97		
CHECKED	97		
MFG. APPR.	97		
APPROVED	97		
DE APPR.	97		
DATE	08.07.07		

DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWING NO. D3804	REV. A SHEET 1 OF 5
TITLE SKIDTUBE ASSEMBLY, 206A/B	SCALE NTS
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W/O:		WORK ORDER CHANGES					
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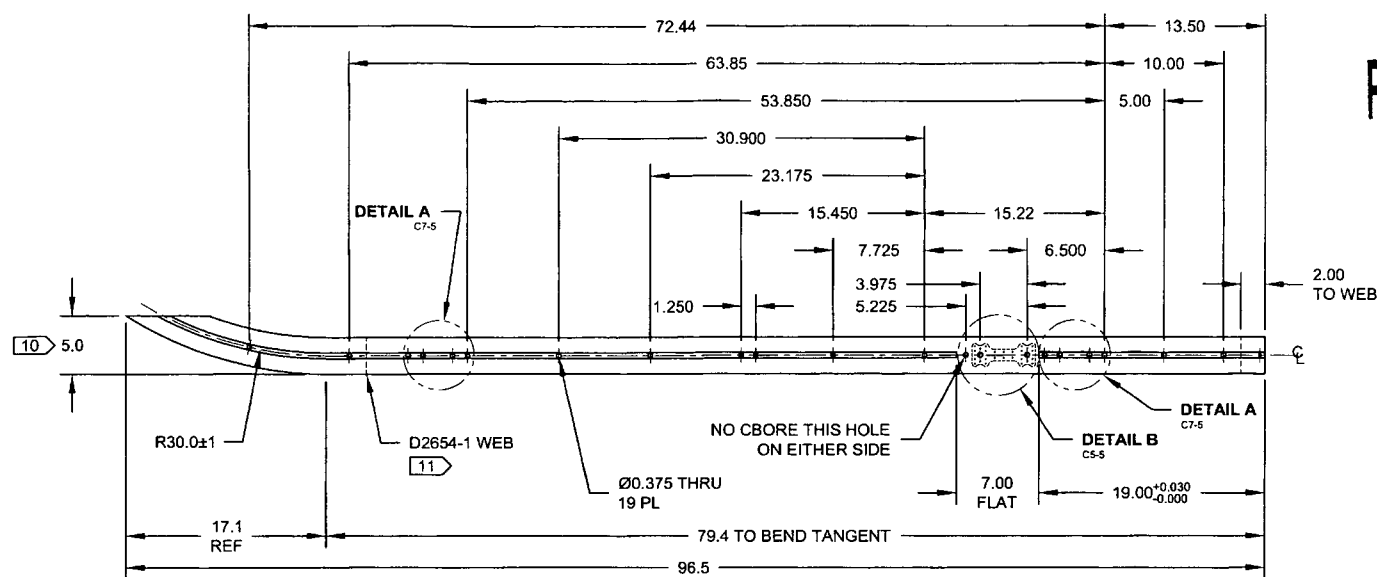
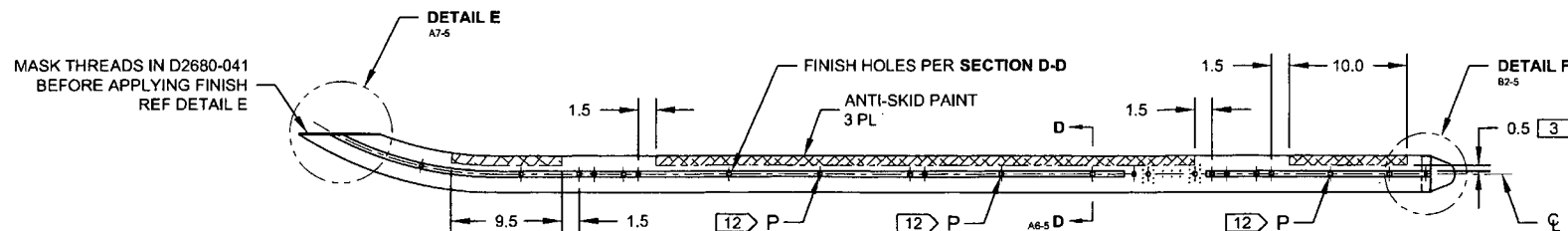
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77068

RELEASED
09.03.03**D3804-041 BENDING/DRILLING DETAIL****D3804-041 ASSEMBLY/FINISHING DETAIL**

DESIGN	91	DART AEROSPACE USA, INC	
DRAWN	1	PORT HADLOCK, WA	
CHECKED	2	DRAWING NO.	REV. A
MFG. APPR.	3	D3804	SHEET 2 OF 5
APPROVED	4	TITLE	SCALE
DE APPR.	5	SKIDTUBE ASSEMBLY, 206A/B	NTS
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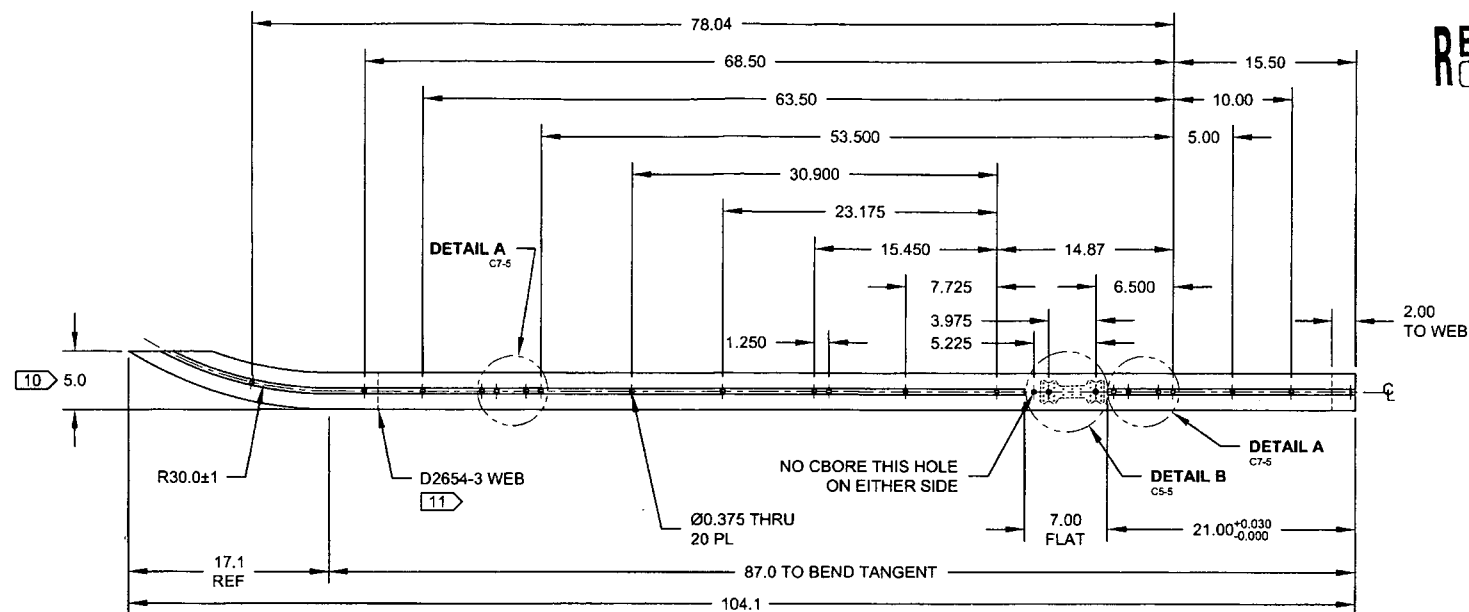
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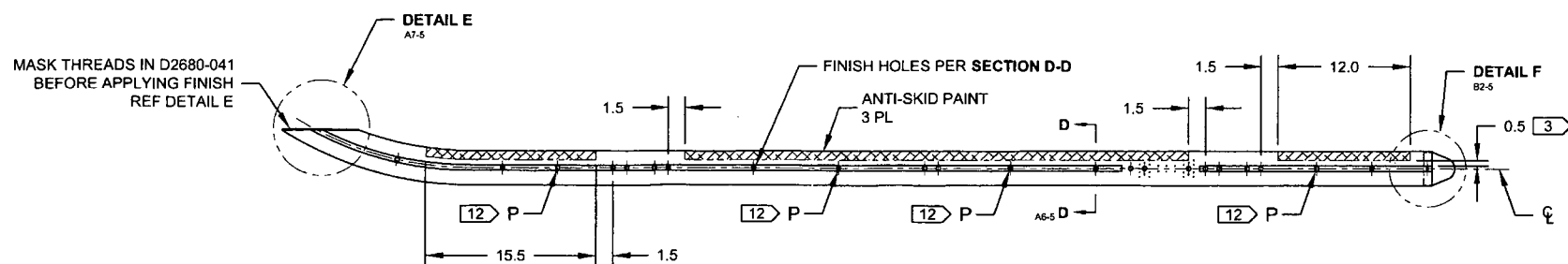
NOTE: Date & initial all entries

27068

RELEASED
09-03-03



D3804-043 BENDING/DRILLING DETAIL



D3804-043 ASSEMBLY/FINISHING DETAIL

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 3 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

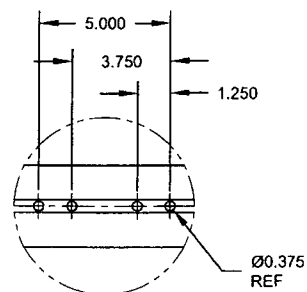
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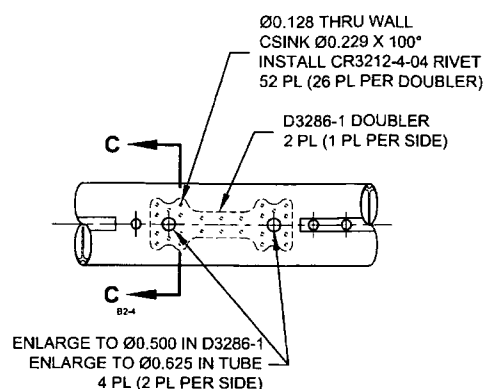
NOTE: Date & initial all entries

77008

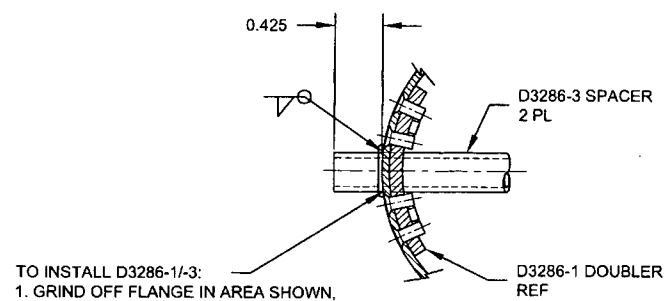
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09-03-03



DETAIL A
SCALE NONE
D6-2
C2-2
D6-3
C2-3

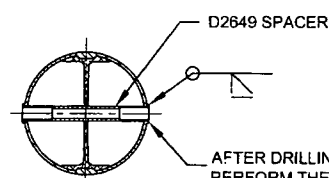


DETAIL B
SCALE NONE
C3-2
C3-3



- TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C
PARTIAL SECTION
SCALE NONE
C6-4



- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

SECTION D-D
FOR Ø0.375 HOLES ONLY
SCALE NONE
A4-2
A4-3

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 4 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
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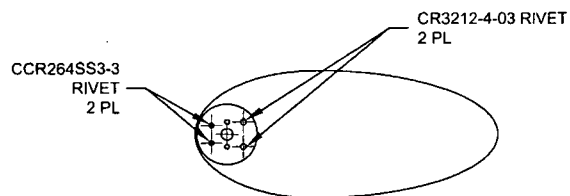
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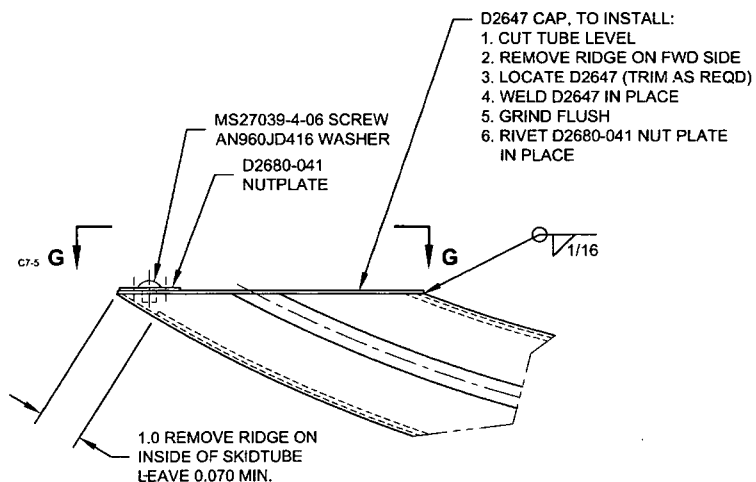
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77068

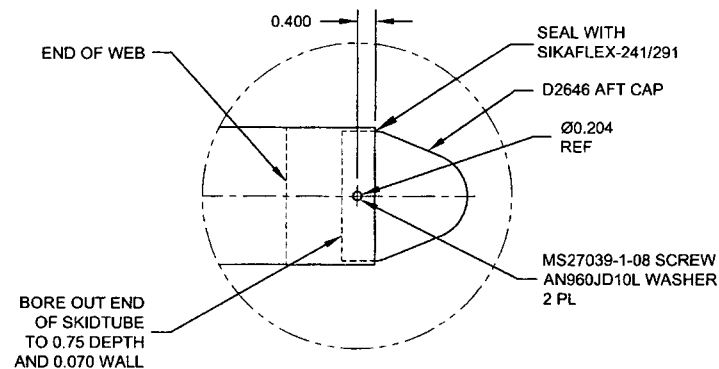
RELEASED
09 09 03 03



VIEW G-G
SCALE NONE A7-5



DETAIL E
SCALE NONE B7-2 B7-3



DETAIL F
SCALE NONE B2-2 B2-3

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	J	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	E	D3804	SHEET 5 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
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NOTE: Date & initial all entries

NO. 274

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 75391
Part number: 206 642 151
Description: 206 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Sal Dunn Date of Test Coupon 11-11-18

Welder Sal Dunn Date of Test Coupon 11-11-18

The above named individual is qualified in accordance with AWS D17.1.2001 to weld